

Work Order ID 150612

Monday, August 29, 2016 2:47:36 PM

150612

Page 1

Item ID: D3794-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Aft

Start Date: 8/26/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

9-89

Date: AUG 31 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3794	Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.12

FLOW CNC Waterjet

1-Cut as per Dwg D3794 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

(13)

DE 16/09/11

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.02

Quality Control

(13)

DE 16/09/11

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.04

Quality Control

X13

DAS
16
9-89

16/09/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		FAULT CATEGORY OTHER : ☐							

Work Order ID 150612

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Page 2

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Revision ID: Stop ***NS2***
Item Name: Gasket Aft
Start Date: 8/26/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: FP-001	0.00							
130									
Packaging	Memo	0.02							
Packaging	LOCATION : FP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89 **SEP 13 2016**
rem 10/09/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, August 29, 2016 2:47:35 PM

Page 1

Work Order ID: 150612

150612

Parent Item: D3794-3

D3794-3

Parent Item Name: Gasket Aft

Start Date: 8/26/2016

Required Date: 8/29/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

93.8568

1.2828

17.104

MNEO60S 063

ac 11/09/11

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

93.856778

M134972

93.856778

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																	
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																	
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																	
OTHER :																																																																				

DART AEROSPACE LTD		Work Order:	150612
Description: Gasket		Part Number:	D3794-3
Inspection Dwg: D3794 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

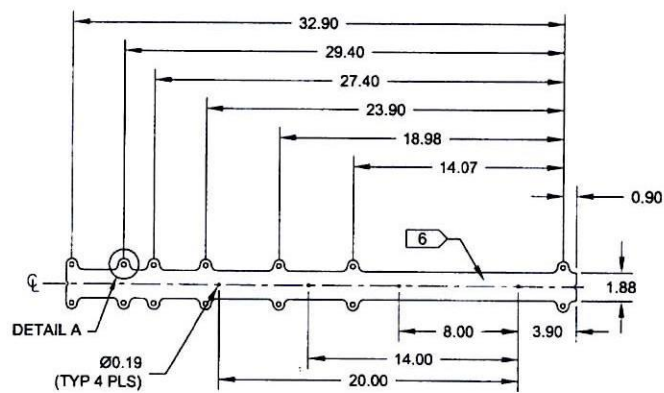
☒ **First Article**

 ☐ **Prototype**

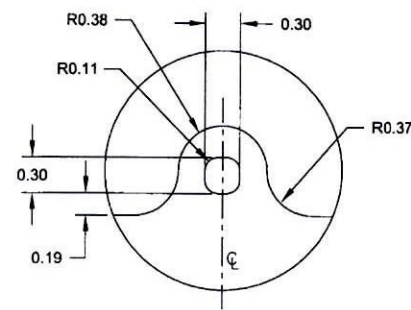
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	Ø.19	'		VC 02-02	
0.300 x 0.300	+/-0.010	.30 x .30	'		Tape	
1.88	+/-0.030	1.88	'			
4.281	+/-0.010	4.281	'			
6.44	+/-0.030	6.44	'			
6.00	+/-0.030	6.00	'			
6.75	+/-0.030	6.75	'			
2.00	+/-0.030	2.00	'			
4.75	+/-0.030	4.75	'			
9.50	+/-0.030	9.50	'			
14.25	+/-0.030	14.25	'			
17.75	+/-0.030	17.75	'			
26.74	+/-0.030	26.74	'			
29.23	+/-0.030	29.23	'			

Measured by:	De	Audited by:	DAS 16	Prototype Approval:	N/A
Date:	16/09/11	Date:	9-89 16/09/12	Date:	N/A

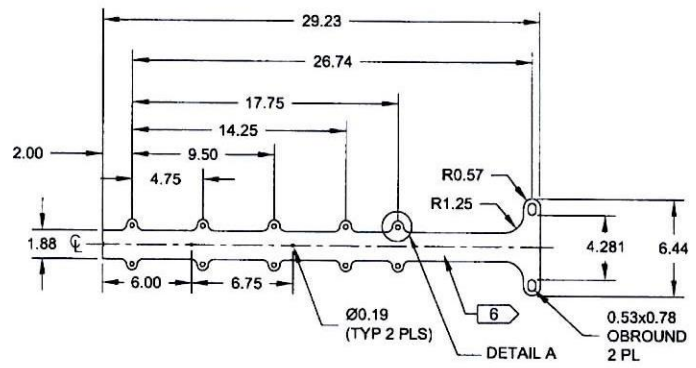
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

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160831

RELEASED
08-05-14

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION		BY DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3794	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GASKET	NTS
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